

20-8388



Dart Aerospace Ltd.
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Canada

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POSITIVE RECALL

EFFECTIVE 20/8/12 AUTH SA

RELEASED 9 DATE 20.8.12



D3144-111

Job Sheet 212137



Part No: D3144-111

Job Qty: 1 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/11/20

Job Tracking No:

Due Date: 8/12/20

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV C IPP A 04.11.29 New issue KJ/RF

Ship Via:

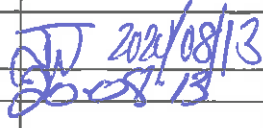
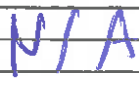
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1		8/11/20	0.17	0.07	Waterjet - Flow		20/08/12
		pcs							
110	QC 2	1		8/11/20	0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/08/12
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		

120 QC 8	1 pcs	8/11/20	0.00 0.00	QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
140 Handfinish - 1-1 Chemical- B4B	1 pcs	8/11/20	0.00 0.12	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	

AUG 12 2020 **DAS**
40
9-99

					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150	Powdercoat - 4 Black Sand - B4B	1 pcs	8/12/20	0.00 0.03	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					Powdercoat - 5 - B4B	
					Powdercoat - 6 - B4B	
					Powdercoat - 7 - B4B	
					Powdercoat - 8 - B4B	
					Powdercoat - 9 - B4B	
					Powdercoat - 10 - B4B	
160	QC 3	1 pcs	8/12/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
					QC 3 - 87	
170	Packaging 3-1 - Stock - B4B	1 pcs	8/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	

DAS 34 9-09

DAS 40 2-00

AUG 13 2020

DAS 21 2-00

AUG 18 2020

<i>Not used per SD 20-08-18</i> <i>SM 20/08/18</i>			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 37 - B4B		
180 QC 21 - SA	1 pcs	8/12/20	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70		
			QC 21 - SA - 9		
			QC 21 - SA - 77		
Part Op 100 - 1-Cut as per Dwg D3144 Dwg Rev: <u> C </u> Prog Rev: <u> C </u> 2-Deburr if necessary Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 140 - Chemical Conversion Coat per QSI005 4.1 150 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 160 - QC3- Inspect Part Finish 170 - Identify as per dwg & Stock Location: _____ 180 - QC21- Final Inspection - Work Order Release					
DAS 44 9-89 26.08.11 M2024T35.080 .23 ss/pg					
Job BOM					
Job BOM records could not be found.					
Job Allocations					
Job Allocations could not be found.					

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	10.270inches ± 0.030	10.300 10.240		
2	Doubler	0.129inches + 0.005 - 0.001	0.134 0.128	Diameter	
3	Doubler	0.400inches ± 0.030	0.430 0.370		
4	Doubler	4.770inches ± 0.030	4.800 4.740		

Plex 8/11/20 8:28 AM Dart.Renwick.Jennifer



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Container No: S293625



Part: D3144 - 111

Job No: 212137

Serial No/Batch: S293625

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

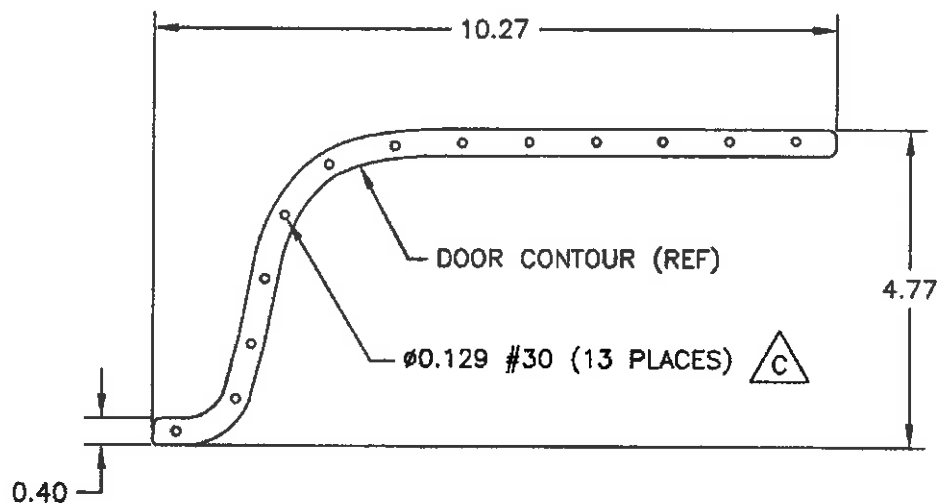
Date: 08/12/20



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3144	REV. C SHEET 9 OF 9
DATE 05.10.19		TITLE DOUBLER	SCALE NTS

RELEASED

05.11.19



D3144-111 DOUBLER (FOR D412-694-01/-02)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 212137

D3144-111 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C9.DWG"

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Entered: 2K Date: AUG 27 2020



NCR No. 20-8385 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>212 137</u> Part No. <u>D3144-111</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☒ Water Jet ☐ Supplier Quality ☐			
Date: <u>AUG 12 2020</u>	Sequence #: <u>100</u>	QTY Affected: <u>1</u>		MRB (QSI042) <u>SAD</u> <u>20/08/11</u> Completed By <u>on 20/08/12</u> Lead hand / Supervisor <u>DAS</u> <u>40</u> <u>9-89</u> <u>AUG 12 2020</u> QC / QA Coordinator <u>DAL</u> <u>9</u> <u>9-89</u> <u>20812</u>	
Description Work Order Deviation <u>Substitute material thickness to correspond to the spacer gap</u> <u>S/N 193543</u> <u>S/N 193545</u> <u>was 0.032 is 0.080</u>		Disposition <u>Acceptable</u>			
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☒ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			